

Work Order ID 128300

January-14-15 12:46:08 PM

128300

Page 1

Item ID: D4309-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 14/01/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 14/01/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4309	A

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FB034 & DWG
FOLIO REV: _____
DWG REV: _____
2-DEBURR AS REQUIRED

10 0 J.C.L. / 15/01/15 DAS 20 9-89

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10 0 J.C.L. / 15/01/15 DAS 20 9-89

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

10 0 J.C.L. / 15-01-15 DAS 37 9-89

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123	Chemical Conversion Coat per QSI005 4.1	0.00							
123									
HandFinish	Memo	0.00							
Hand Finishing									
126	QC7-Inspect Chemical Conversion Coat	0.00							
126									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>Stoqa</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									

10x of 10 12012e

10 DAS 38 9-89

JAN 29 2015

10 DAS 38 9-89 JAN 31 2015

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLS 1502-02

15.2-2

Picklist Print

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1

Work Order ID: 128300

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Parent Item: D4309-1

D4309-1

Parent Item Name: Bushing

Start Date: 14/01/2015

Required Date: 14/01/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 11-01-11 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased	No			100	f	20.0950	0.08333	1			
M6061T6R0 500									**	J.L.L.			
6061-T6 Round Bar .500"													

Location

Loc Qty

Loc Code

MAT012

20.095

M128247

3.565

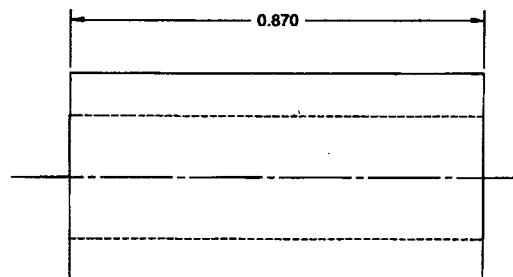
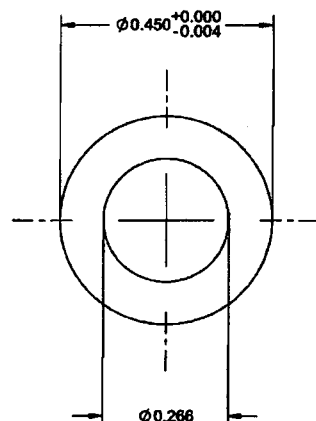
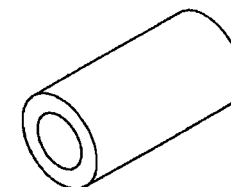
M129845

12.66

M130043

3.87

0.849 15/01/15



D4309-1 BUSHING

RELEASED
2011-05-26

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T8R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.7
- 7) WEIGHT: 0.03 lbs

A NEW ISSUE		CP	11.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.01.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4309

REV. A

SHEET 1 OF 1

TITLE
BUSHING

SCALE

NTS

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Alex Pharand

To: 'Jean-Luc Menard (jmenard@dartaero.com)'
Cc: Steven Drouin
Subject: 206 style step for 119

We need 6 more bushings D4309-1, you had made two previously for muffin because we didn't have any in stock. I believe you made them out of a different material than what is specified on the drawing